

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2016-137 Date Opened: 13 Oct 2016 Title: Fabrication

Aircraft OEM: Bell Aircraft Model: 212 Product Type: High Beams Product Model: N/A Quantity: 2 set

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
DB
DB
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100632	0	Fwd High Beam	DB
100633	0	Aft High Beam	DB
100635	0	Strut Fabrication	DB
100606	0	High Mounted Prov. Inst.	DB

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

2 set
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tags Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
JC
JC
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: J. Clarke

ICC / Dual Inspection performed by:

Print: J. Rekve

Work Order closed by:

Print: J. Clarke

Sign:

Sign:

Sign:

SCA: AD02

SCA: AD01

SCA: AD02

Date: 23 NOV 2018

Date: 23 NOV 2018

Date: 26 NOV 2018

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

ROD END FABRICATION-100635

General

These instructions apply to Threaded Rod End 100635-09 for mounting Bell 205/212/412 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

100635, Revision 0-Strut Fabrication

Work Order: 2016-137

Batch Quantity: 8

Complete
(initial or SCA #)

Date Open: 13 OCT 2016

AD
73-04
02

1. Stock Preparation

- Cut 0.75 round stock, over 4' long.
- Cut 5/16-24 threaded rod to 2' long.
- Record material PO on attached material list.
- De-burr cut ends.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining.

2. Turning-100635-10 Threaded Bushing

- Load part in collet in lathe.
- Face end at 1030 RPM, 0.01 in/rev.
- Turn OD to tight fit inside strut tube (3/4 x 0.065 tube) at 1030 RPM, 0.04 in/rev.
- Deburr.
- Cut or part turned section, min 0.58 long.
- Load part in collet in lathe, on turned section.
- Face end to length at 1030 RPM, 0.01 in/rev.
- Centre drill.
- Tap drill I (0.272) at 300 RPM.
- Tap 5/16-24.
- Deburr.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD
73-04
02

3. Turning-100635-11 Threaded Rod

- Load part in collet in lathe.
- Face end at 1030 RPM, 0.01 in/rev.
- Deburr.
- Flip part, face end to length at 1030 RPM, 0.01 in/rev.
- Deburr.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD
73-04
02

4. Welding

- Thread rod into bushing, flush with inside end.
- TIG weld threaded rod to bushing using ER308L Rod.
- Tag completed parts and place on in-progress shelf in welding shop for further assembly.

AD
73-04
02

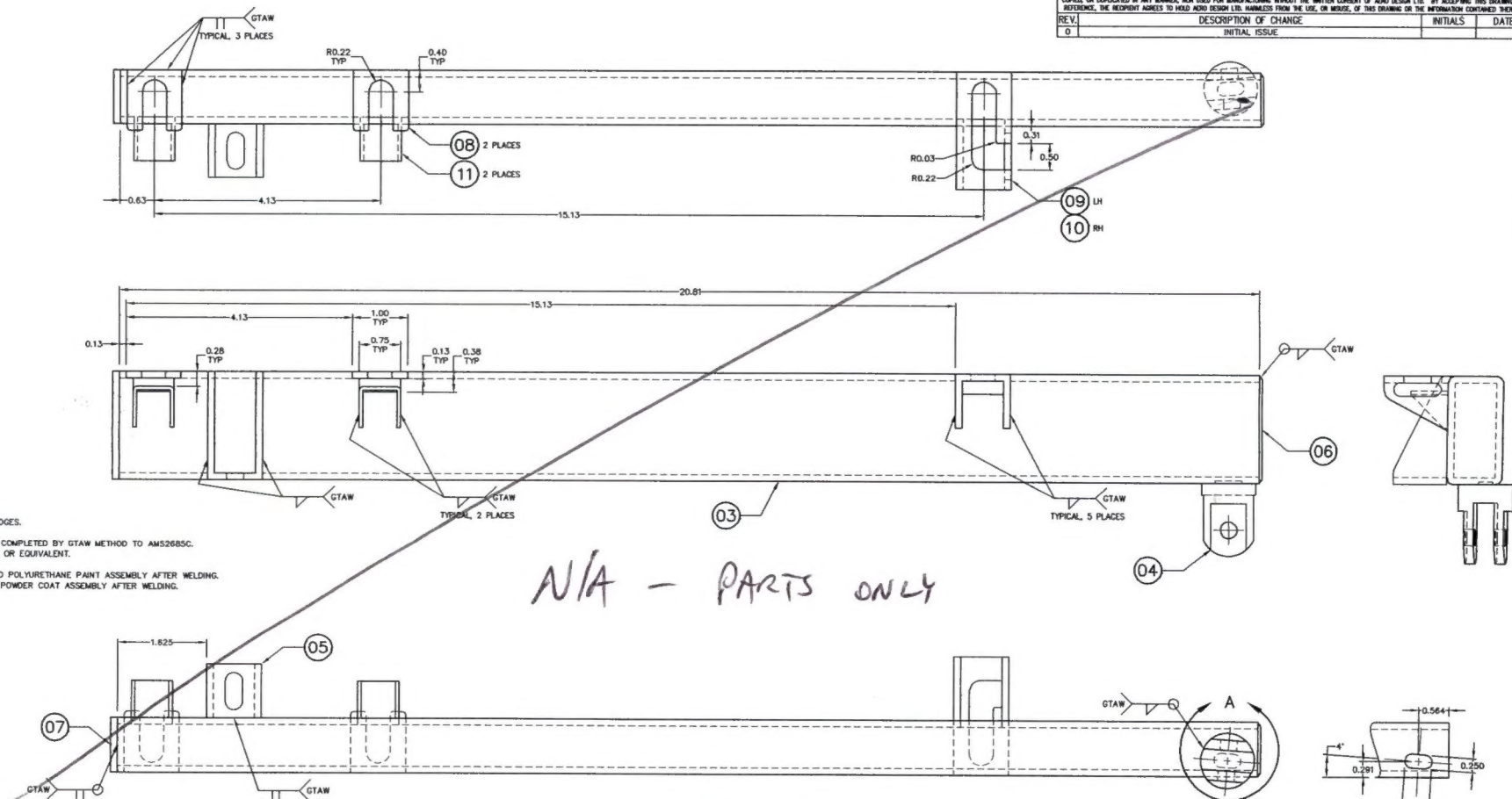
Aero Design

Parts Distribution Sheet

Description: Mega Basket Beams

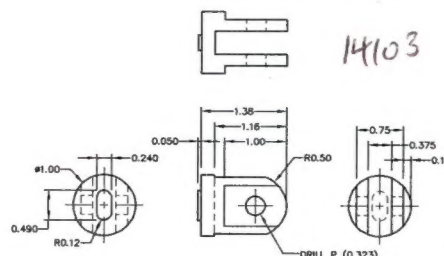
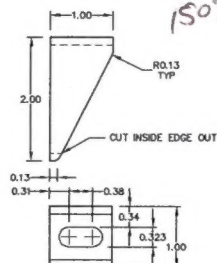
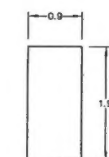
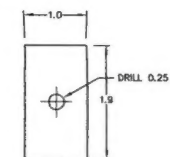
WO# 2016-137

[illegible]



NOTES


1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ASSEMBLY AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ASSEMBLY AFTER WELDING.



02 RH FORWARD BEAM
01 LH FORWARD BEAM
RH SHOWN, LH OPPOSITE

DETAIL A
BEFORE WELDING

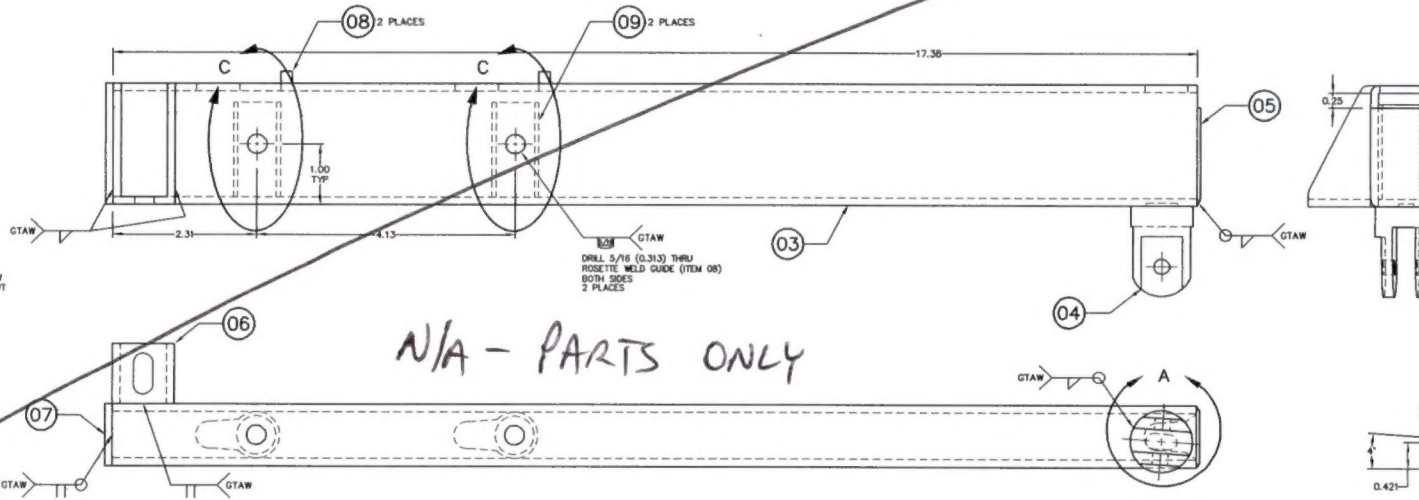
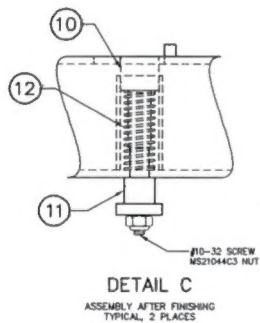
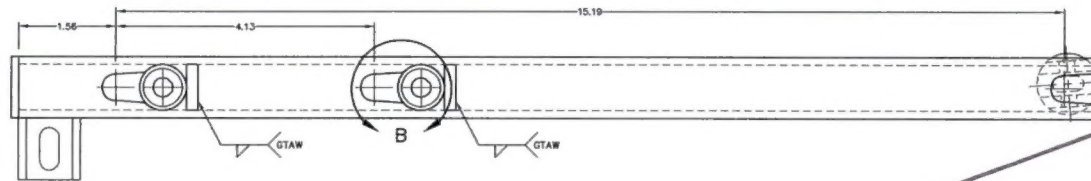
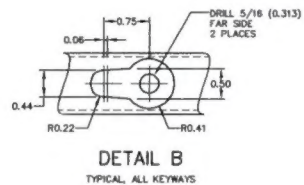
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1	1	78633-04-01	10	RH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	78633-04-02	09	LH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
2	2	78633-03	08	GUIDE	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-07	07	CAP	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-06	06	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	1	100630-05	05	BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100630-04	04	FITTING	304 STAINLESS STEEL	ASTM A479	#10 ROD
1	1	100630-03	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100630-01-02	02	RH FORWARD BEAM (LOW MOUNT)			
1	1	100630-01-01	01	LH FORWARD BEAM (LOW MOUNT)			
Q2	Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY						

APPROVALS		DATE		AERO DESIGN LTD.	
DRAWN: JEFF CLARKE		18 DEC 2014		8085A MALASPINA ROAD	
CHECKED: JASON REKVE		18 DEC 2014		POWELL RIVER, BC, CANADA, V9A 0G5 TEL: 254-484-3879 WWW.AERODESIGN.CA	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			BELL 205, 212, 214, 412 SERIES QUICK RELEASE COUNTING PROVISIONS FORWARD BEAM FABRICATION (LOW MOUNT)		
DECIMALS		ANGLES			
X.XXX ±0.010		±1/2°			
X.XX ±0.03					
X.X ±0.1					
SHEET 1 : 1			DWS. SIZE	DWS. NO.	REV.
SCALE 1 OF 1			A1	100630	0

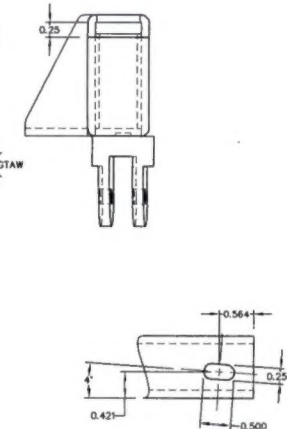
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BELL 205, 212, 214, 412 SERIES
QUICK RELEASE MOUNTING PROVISIONS
FORWARD BEAM FABRICATION (LOW MOUNT)

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0	INITIAL ISSUE		



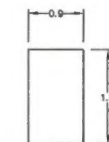
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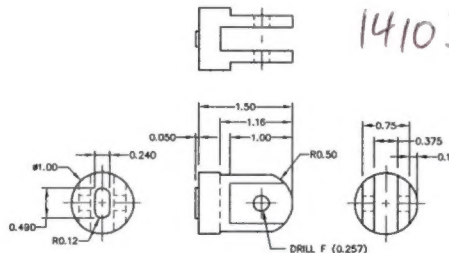
02 RH AFT BEAM
01 LH AFT BEAM
RH SHOWN, LH OPPOSITE

DETAIL A
BEFORE WELDING
SLOT 0.06 DEEP

- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
 3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ASSEMBLY AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ASSEMBLY AFTER WELDING.



05 CAP



04 FITTING

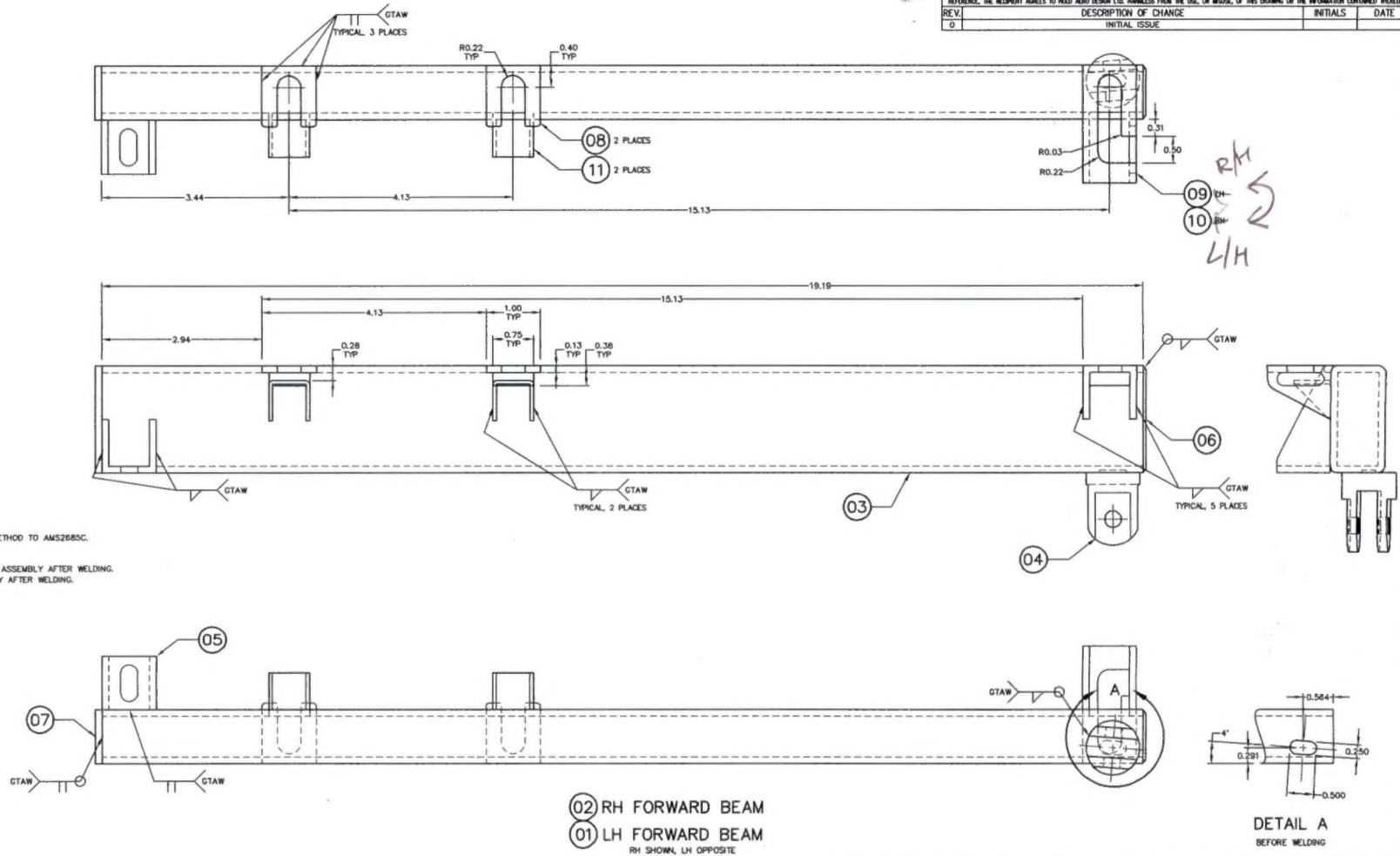
QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	2	MS21044C3	NUT		STAINLESS STEEL	COMMERCIAL	
2	2	89830-1032 X 3	C/SUNK SCREW		STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
2	2	69830-23 12	SPRING		STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
2	2	69830-22 11	KNOB		6061-T6 ALUMINUM	QQ-A-200/B	#0.75 ROD
2	2	69830-21 10	STOP		6061-T6 ALUMINUM	QQ-A-200/B	#0.625 ROD
2	2	69830-11 09	GUIDE		304 STAINLESS STEEL	ASTM A240	#0.75 X 0.063 RND. TUBE
1	1	69830-07 08	BLOCK		304 STAINLESS STEEL	ASTM A479	0.188 SQR. ROD
1	1	100630-07 07	CAP		304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-05 06	BRACKET		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100631-05 05	CAP		304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	1	100631-04 04	FITTING		304 STAINLESS STEEL	ASTM A479	1.0 ROUND BAR
1	1	100631-03 03	TUBE		304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
		100631-01-02 02	RH AFT BEAM (LOW MOUNT)				
		100631-01-01 01	LH AFT BEAM (LOW MOUNT)				
02	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY						

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	18 DEC 2014
CHECKED: JASON REKVE	18 DEC 2014

AERO DESIGN LTD.			
8828A MALASPINA ROAD POWELL RIVER, BC, CANADA, V0A 0G5 TEL: 854.483.2276 www.aerodesign.ca			
BELL 205, 212, 214, 412 SERIES QUICK RELEASE MOUNTING PROVISIONS AFT BEAM FABRICATION (LOW MOUNT)			
SCALE 1 : 1	QWS SIZE	QWS NO.	REV.
SHEET 1 OF 1	A1	100631	0

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		




NOTES

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3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ASSEMBLY AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ASSEMBLY AFTER WELDING.

2	2	78633-05	11	STOP BRACKET	304 STAINLESS STEEL	ASTM A554	0.75 X 0.035 SQ. TUBE
1	1	78633-04-02	10	LH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	78633-04-01	09	RH UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
2	2	78633-03	08	GUIDE	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-07	07	CAP	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	100630-06	06	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	1	100630-05	05	BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100630-04	04	FITTING	304 STAINLESS STEEL	ASTM A479	#1.0 ROD
1	1	100632-03	03	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100632-01-02	02	RH FORWARD BEAM (HIGH MOUNT)			
1	1	100632-01-01	01	LH FORWARD BEAM (HIGH MOUNT)			
02	01		ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY				LIST OF MATERIALS		

APPROVALS		DATE	
DRAWN: JEFF CLARKE		18 DEC 2014	
CHECKED: JASON REKVE		18 DEC 2014	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
DECIMALS		ANGLES	
X.XXX ±0.010		±1/2°	
X.XX ±0.03			
X.X ±0.1			
SCALE 1 : 1		DWG. SIZE	
SHEET 1 OF 1		REV.	
		A1 100632 0	

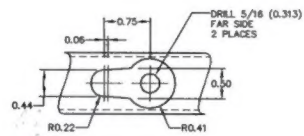
		AERO DESIGN LTD.	
		8886A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 250-683-9378 FAX: 250-683-9379	
		BELL 205, 212, 214, 412 SERIES QUICK RELEASE MOUNTING PROVISIONS FORWARD BEAM FABRICATION (HIGH MOUNT)	



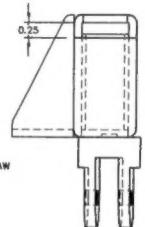
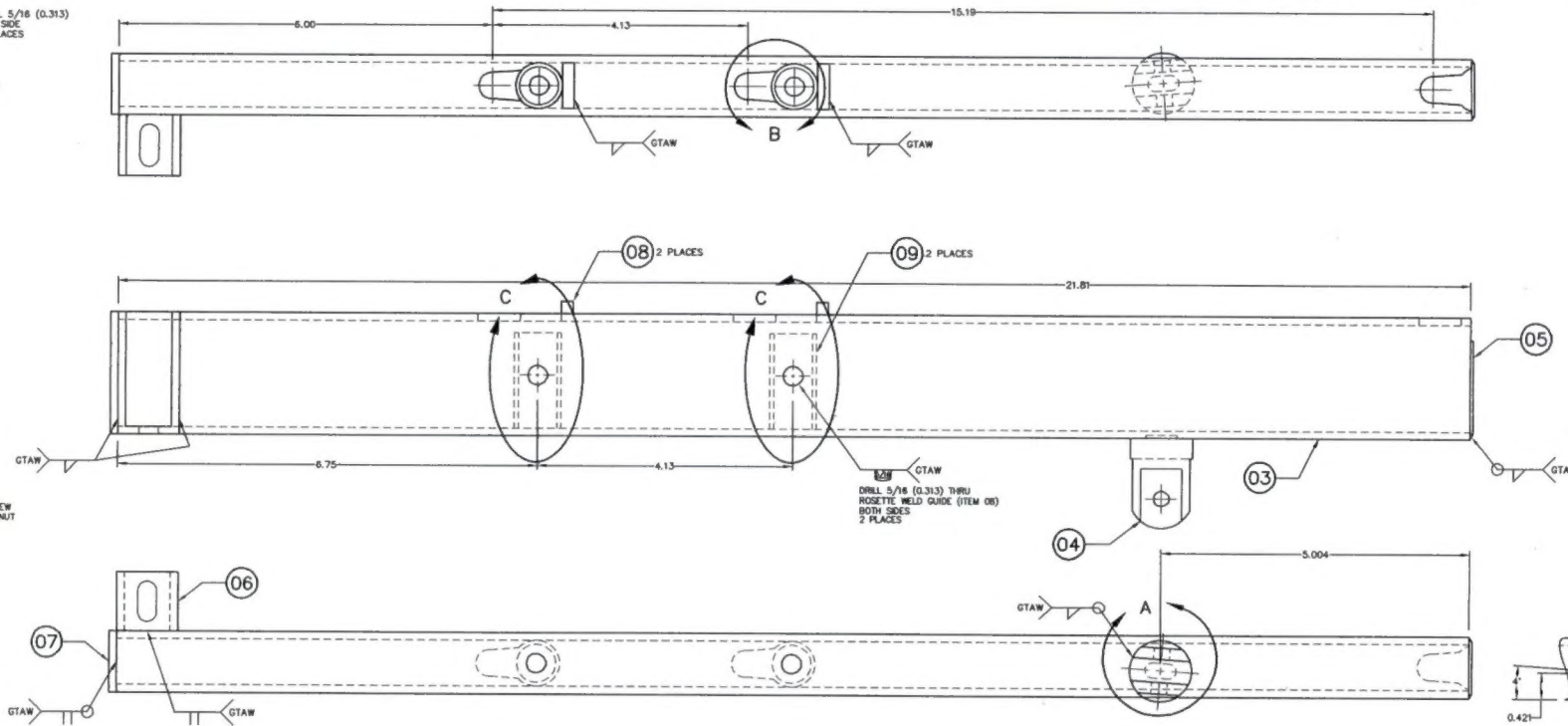
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BELL 205, 212, 214, 412 SERIES
QUICK RELEASE MOUNTING PROVISIONS
FORWARD BEAM FABRICATION (HIGH MOUNT)

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



DETAIL B
TYPICAL ALL KEYWAYS



DETAIL A
BEFORE WELDING
SLOT 0.06 DEEP

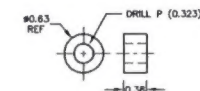
02 RH AFT BEAM
01 LH AFT BEAM
RH SHOWN, LH OPPOSITE

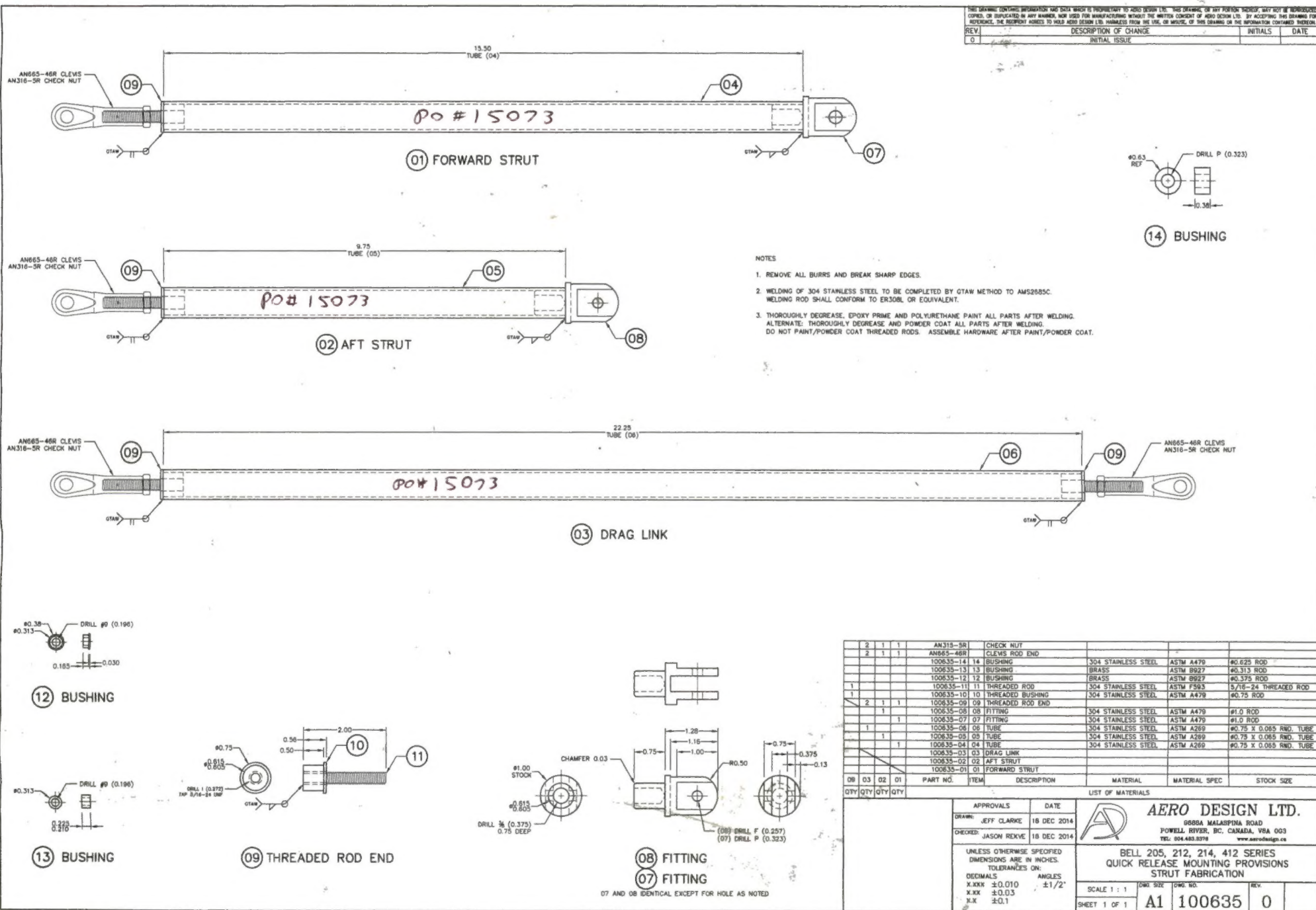
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT ASSEMBLY AFTER WELDING. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ASSEMBLY AFTER WELDING.

2	2	MS21044C3	NUT	STAINLESS STEEL	COMMERCIAL	
2	2	69830-1032 X 3	C'SUNK SCREW	STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
2	2	69830-23	12 SPRING	STAINLESS STEEL	COMMERCIAL	15mm X 70mm SPRING
2	2	69830-22	11 KNOB	6061-T6 ALUMINUM	00-A-200/B	#0.75 ROD
2	2	69830-21	10 STOP	6061-T6 ALUMINUM	00-A-200/B	#0.625 ROD
2	2	69830-11	09 GUIDE	304 STAINLESS STEEL	ASTM A269	#0.75 X 0.065 RND. TUBE
1	1	69830-07	08 BLOCK	304 STAINLESS STEEL	ASTM A479	0.188 SQR. ROD
1	1	100630-07	07 CAP	304 STAINLESS STEEL	ASTM A420	1.0 X 0.125 BAR
1	1	100630-05	06 BRACKET	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	1	100631-05	05 CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	1	100631-04	04 FITTING	304 STAINLESS STEEL	ASTM A479	1.0 ROUND BAR
1	1	100633-03	03 TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
100633-01-02 02 RH AFT BEAM (HIGH MOUNT)						
100633-01-01 01 LH AFT BEAM (HIGH MOUNT)						
QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
LIST OF MATERIALS						
APPROVALS				DATE	AERO DESIGN LTD.	
DRAWN: JEFF CLARKE				18 DEC 2014	9086A MALASPINA ROAD	
CHECKED: JASON REKVE				18 DEC 2014	POWELL RIVER, BC, CANADA, V8A 0G5	
UNLESS OTHERWISE SPECIFIED					TEL: 604.483.2376	
DIMENSIONS ARE IN INCHES.					WWW.AERODESIGN.CA	
TOLERANCES ON:					BELL 205, 212, 214, 412 SERIES	
DECIMALS					QUICK RELEASE MOUNTING PROVISIONS	
X.XXX ±0.010					AFT BEAM FABRICATION (HIGH MOUNT)	
X.XX ±0.03					SCALE 1 : 1	DWG. NO.
X.X ±0.1					SHEET 1 OF 1	REV.
					A1	100633
						0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

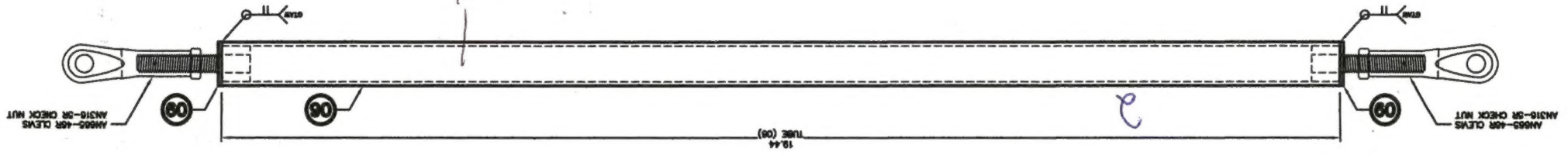
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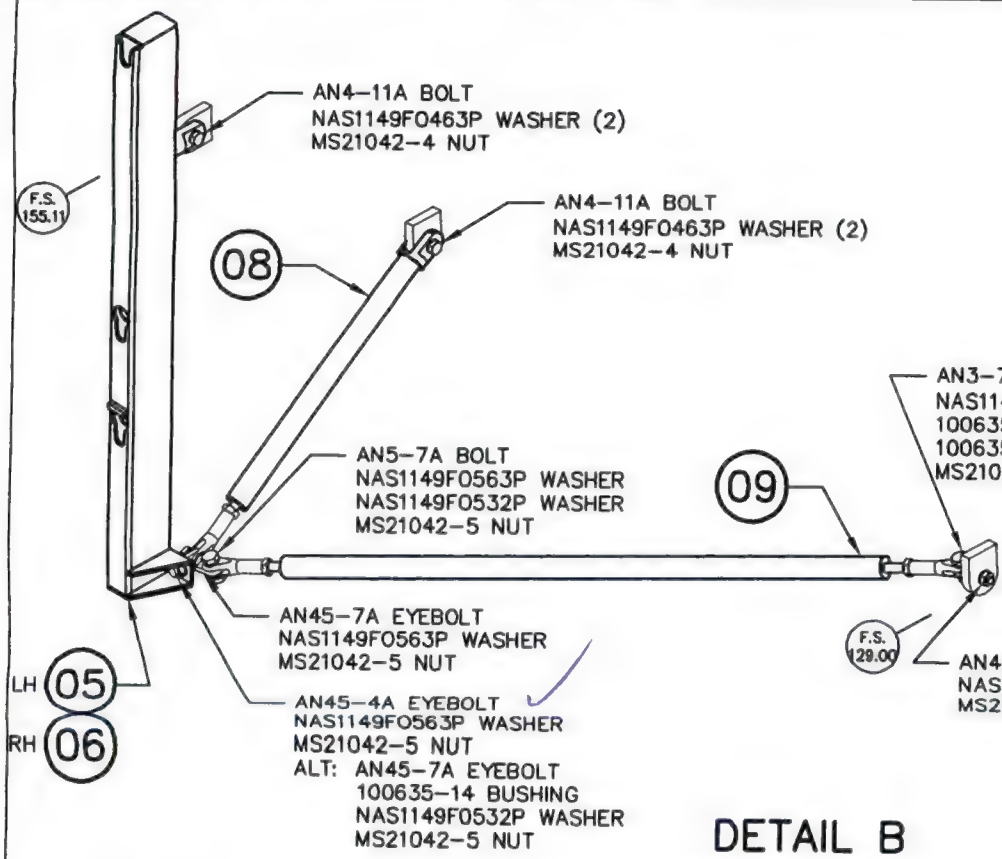
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212

15073

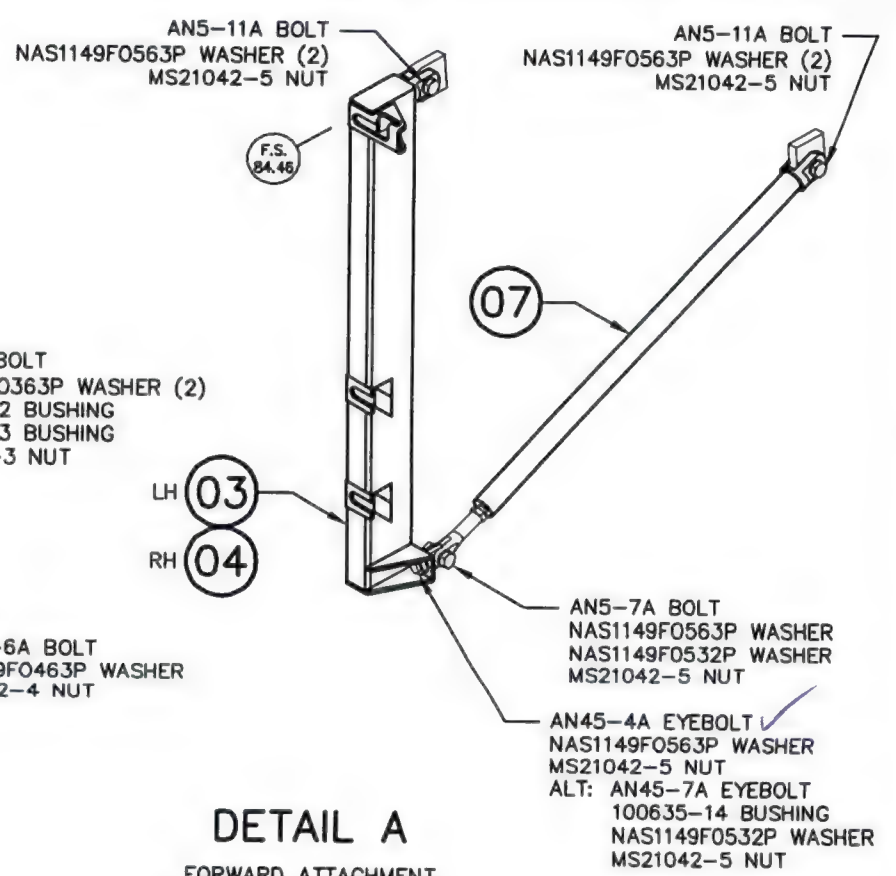


Alpine



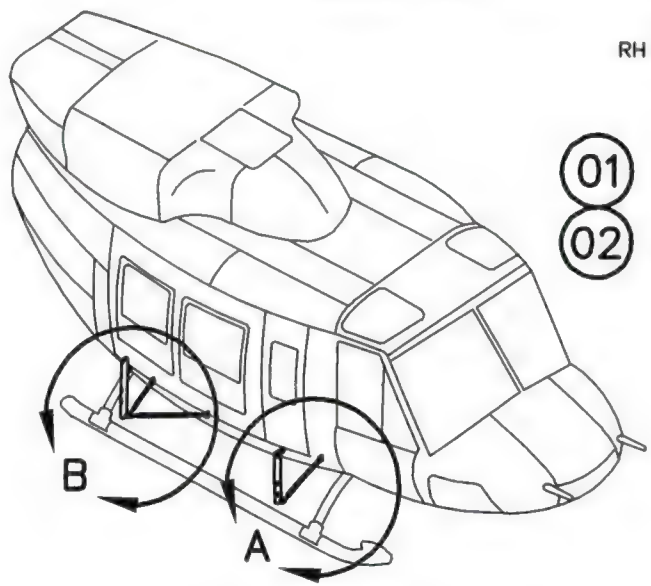
DETAIL B

AFT ATTACHMENT
RH SHOWN, LH OPPOSITE




DETAIL A

FORWARD ATTACHMENT
RH SHOWN, LH OPPOSITE



- 01 QUICK RELEASE MOUNTING PROVISIONS, HIGH, LH
- 02 QUICK RELEASE MOUNTING PROVISIONS, HIGH, RH

APPROVALS		DATE		 <div>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.423.2776 www.aerodesign.ca</div>	
DRAWN: JEFF CLARKE		13 JAN 2015			
CHECKED: JASON REKVE		13 JAN 2015			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				BELL 205A-1, 205B, 212, 412, 412EP, 412CF QUICK RELEASE MOUNTING PROVISIONS HIGH MOUNTED INSTALLATION	
NOT TO SCALE		DWG. SIZE	DWG. NO.	REV.	
SHEET 1 OF 2		A4	100606	0	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

NOTES:

1. SEE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS, ICA751.90, FOR MAINTENANCE INFORMATION.

2. INSTALLATION PROCEDURE:

- INSTALL FORWARD AND AFT BEAM ON UPPER FUSELAGE HARD POINTS. DO NOT FULLY TIGHTEN BOLTS.
- INSTALL FORWARD AND AFT STRUTS FROM BEAM TO LOWER FUSELAGE HARD POINTS. DO NOT TIGHTEN BOLTS.
- ALIGN FORWARD AND AFT BEAMS TO BE PARALLEL WHEN VIEWED FROM THE FRONT OR BACK. THREAD CLEVIS ON STRUTS IN OR OUT TO ADJUST.
- INSTALL DRAG LINK FROM AFT BEAM TO LOWER FUSELAGE HARD POINT AT FS. 129.00. THREAD CLEVIS ON BOTH ENDS IN OR OUT TO ADJUST.
- ADJUST DRAG LINK FOR CENTRE TO CENTRE SPACING OF BEAMS TO 71.0 INCHES (1803 mm).
- TIGHTEN ALL FASTENERS AND CHECK NUTS PER NOTE 3.

3. TORQUE FASTENERS AS FOLLOWS:

- AN3 BOLTS: 12-15 IN-LBS (1.36-1.69 N-m)
- AN4 BOLTS: 30-40 IN-LBS (3.39-4.52 N-m)
- AN5 BOLTS, AN316-5 CHECK NUTS: 60-85 IN-LBS (6.78-9.60 N-m)
- AN43 EYE BOLT: 50-70 IN-LBS (5.65-7.91 N-m)
- AN45 EYE BOLTS: 100-140 IN-LBS (11.30-15.82 N-m)

1	1	MS21042-3	NUT (ALT: MS21042L3, MS21044N3)
3	3	MS21042-4	NUT (ALT: MS21042L4, MS21044N4)
7	7	MS21042-5	NUT (ALT: MS21042L5, MS21044N5)
2	2	NAS1149F0363P	WASHER
5	5	NAS1149F0463P	WASHER
2	2	NAS1149F0532P	WASHER
9	9	NAS1149F0563P	WASHER
1	1	AN3-7A	BOLT
1	1	AN43B-6A	EYE BOLT
2	2	AN4-11A	BOLT
1	1	AN45-7A	EYE BOLT
2	2	AN45-4A	EYE BOLT (ALT: AN45-7A WITH 100635-14 BUSHING)
2	2	AN5-7A	BOLT
2	2	AN5-11A	BOLT
1	1	100635-13	BUSHING
1	1	100635-12	BUSHING
1	1	100635-03	09 DRAG LINK
1	1	100635-02	08 AFT STRUT
1	1	100635-01	07 FORWARD STRUT
1		100633-01-02	06 AFT BEAM, HIGH MOUNTED, RH
	1	100633-01-01	05 AFT BEAM, HIGH MOUNTED, LH
1		100632-01-02	04 FORWARD BEAM, HIGH MOUNTED, RH
	1	100632-01-01	03 FORWARD BEAM, HIGH MOUNTED, LH
		100606-01-02	02 QUICK RELEASE MOUNTING PROVISIONS, HIGH, RH
		100606-01-01	01 QUICK RELEASE MOUNTING PROVISIONS, HIGH, LH
02	01	PART NO.	ITEM DESCRIPTION
QTY	QTY	LIST OF MATERIALS	

WEIGHT AND BALANCE - METRIC

ITEM	DESCRIPTION	WEIGHT (kg)	LONGITUDINAL		LATERAL	
			ARM (mm)	MOMENT (mm-kg)	ARM (mm)	MOMENT (mm-kg)
01	QUICK RELEASE MOUNTING PROVISIONS HIGH MOUNTED, LH	5.3	3150	16695	-1165	-6175
02	HIGH MOUNTED, RH	5.3	3150	16695	1165	6175

WEIGHT AND BALANCE - STANDARD

ITEM	DESCRIPTION	WEIGHT (LB)	LONGITUDINAL		LATERAL	
			ARM (IN)	MOMENT (LB-IN)	ARM (IN)	MOMENT (LB-IN)
QUICK RELEASE MOUNTING PROVISIONS INSTALLATION						
01	HIGH MOUNTED, LH	11.6	124.02	1438.6	-45.88	-532.2
02	HIGH MOUNTED, RH	11.6	124.02	1438.6	45.88	532.2

APPROVALS	DATE
DRAWN: JEFF CLARKE	13 JAN 2015
CHECKED: JASON REKVE	13 JAN 2015



AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.463.8376 www.aerodesign.ca

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

BELL 205A-1, 205B, 212, 412, 412EP, 412CF
QUICK RELEASE MOUNTING PROVISIONS
HIGH MOUNTED INSTALLATION

NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 2 OF 2	A4	100606	0

Work Order: 2016-137Material Tracking Sheet
Bell 205/212 Mounting Beam Struts

1 of 2

Date Open: 13 Oct 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	2		100635-01	Forward Strut		
. 1			100635-04	Tube	304 Stainless, 3/4" x 0.065" Rnd. Tube	14103/15073
. 1			100635-07	Fitting	304 Stainless, 1.0 Round	14103/17106
. 1			100635-09	Threaded Rod End		below
. A/R			ER308L	Welding Rod		14028
. 1			AN665-46R	Clevis End		See PDS
. 1			AN315-5R	Check Nut		See PDS
. 1			--	P/N Placard	TZ Tape, 1/2"	commercial
	2		100635-02	Aft Strut		
. 1			100635-05	Tube	304 Stainless, 3/4" x 0.065" Rnd. Tube	14103/15073
. 1			100635-08	Fitting	304 Stainless, 1.0 Round	14103/17106
. 1			100635-09	Threaded Rod End		below
. A/R			ER308L	Welding Rod		14028
. 1			AN665-46R	Clevis End		See PDS
. 1			AN315-5R	Check Nut		See PDS
. 1			--	P/N Placard	TZ Tape, 1/2"	commercial
	2		100635-03	Drag Link		
. 1			100635-06	Tube	304 Stainless, 3/4" x 0.065" Rnd. Tube	14103/15073
. 1			100635-08	Fitting	304 Stainless, 1.0 Round	N/A
. 2			100635-09	Threaded Rod End		below
. A/R			ER308L	Welding Rod		14028
. 2			AN665-46R	Clevis End		See PDS
. 2			AN315-5R	Check Nut		See PDS
. 1			--	P/N Placard	TZ Tape, 1/2"	commercial
	8		100635-09	Threaded Rod End	(4 per set)	
. 1			100635-10	Threaded Bushing	304 Stainless, 3/4" Rod	15073
. 1			100635-11	Threaded Rod	304 Stainless, 5/16-24 Threaded Rod	14104/16071
. A/R			ER308L	Welding Rod		14028

Date Open: 13 OCT 2016

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		100635-12	Bushing	Brass, 3/8" Rod	13050
	1		100635-13	Bushing	Brass, 5/16" Rod	16043
	0		100635-14	Bushing*	304 Stainless, 5/8" Rod	
				*(only required for long eyebolts)		

AFT MOUNTING BEAM FABRICATION – 100631/100633

General

These instructions apply to aft mounting beams 100631-01-XX (Low) and 100633-01-XX (High) for Bell 205/212/412 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

100631, Revision 0 – Aft Beam Fabrication, Low
100633, Revision 0 – Aft Beam Fabrication, High

Work Order: 2016-137

Complete
(initial or SCA #)

Date Open: 13 OCT 2016

Batch Qty: 2 x RH HIGH

#1	#2	#3	#4	#5
AD	AD			
73-04	73-04			
02	02			

1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.12 material as indicated on drawings.
 - 100631-01: 100631-03 (tube), 17.38" long
 - 100633-01: 100633-03 (tube), 21.81" long
- Record material PO on attached material list.
- De-burr cut ends.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD	AD			
73-04	73-04			
02	02			

2. CNC Machining - Tube

- Run CNC programs to machine slots in 100631-03 / 100633-03 tube.
- De-burr keyways, slots and holes.
- On manual mill, machine bottom of keyhole with long $\frac{3}{4}$ " end mill.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD	AD			
73-04	73-04			
07	07			

3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear cap 100630-06 from 0.050 sheet.
- Cut 100630-07 cap from 1x0.125 flat bar.
- Cut and turn 69830-11 guide tubes from 0.75 x 0.065 tube:
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Cut 69830-07 blocks.
- Fabricate 100630-05 bracket, see work sheet.
- Fabricate 100631-04 fitting, see work sheet.
- Record component POs / WOs on attached material list.

AFT MOUNTING BEAM FABRICATION – 100631/100633

Complete

(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD			
73-04	73-04			
05	05			

4. Beam Welding

- TIG weld 69830-11 guide tubes into 100631-03 or 100633-03 tubes using ER308L rod, two places per tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld components using ER308L rod:
 - 100630-05 bracket to side of tube using ER308L rod.
 - 100631-04 fitting to back of tube, seat in slot on tube.
 - 100631-05 cap to top of tube.
 - 100630-07 cap to bottom of tube.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts for finishing.

AD				
73-04				
01	dk			

5. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams 100631-01-00 or 100633-01-00 for conformity to drawing.
- Tag in-progress parts ready for powder coating.

AD	AD		
73-04	73-04		
02	02		

6. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD	AD		
73-04	73-04		
02	02		

7. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.
- Adhere P/N placard to top surface of beam, between strap and end on top surface.
- Ensure AN4 bolt can be inserted through lugs.
- Green tag completed beam assemblies and place into stock.

FORWARD MOUNTING BEAM FABRICATION – 100630/100632

General

These instructions apply to forward mounting beams 100630-01-XX (Low) and 100632-01-XX (High) for Bell 205/212/412 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

100630, Revision 0 – Forward Beam Fabrication, Low

→ 100632, Revision 0 – Forward Beam Fabrication, High

Work Order: 2016-137

Complete
(initial or SCA #)

Date Open: 13 OCT 2016

Batch Qty: 2 x RH HIGH

#1 AD 73-04 02	#2 AD 73-04 02	#3	#4	#5
-------------------------	-------------------------	----	----	----

1. Beam Fabrication – 1x2 tubes

- Cut 1 x 2 x 0.12 material as indicated on drawings.
 - 100630-01: 100630-03 (tube), 20.81" long
 - 100632-01: 100632-03 (tube), 19.19" long
- Record material PO on attached material list.
- De-burr cut ends.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD 73-04 02	AD 73-04 02			
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2. CNC Machining - Tube

- Run CNC programs to machine slots in 100630-03 / 100632-03 tube.
- De-burr keyways, slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 01	AD 73-04 01			
-------------------	-------------------	--	--	--

3. Beam Fabrication – Components

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear cap 100630-06 from 0.050 sheet.
- Cut 100630-07 cap and 78633-03 guide from 1x0.125 flat bar.
- Cut 78633-05 stop bracket from 0.75x0.75x0.035 tube.
- Fabricate 100630-05 bracket, see work sheet.
- Fabricate 100630-04 fitting, see work sheet.
- Fabricate 78633-04 upper guide, see work sheet.
- Record component POs / WOs on attached material list.

AD 73-04 05	AD 73-04 05			
-------------------	-------------------	--	--	--

4. Beam Welding

- TIG weld 78633-04-XX upper guide (1 place, top slot) and 78633-03 guide (2 places) into tube 100630-03 or 100632-03 using ER308L rod.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts for straightening.

FORWARD MOUNTING BEAM FABRICATION – 100630/100632

Complete

(initial or SCA #)

#1
AD

#2
AD

#3

#4

#5

73-04 73-04

5. CNC Machining

- Run CNC programs to machine keyways in 100630-03 or 100632-03 tubes with guides welded in place.
- De-burr keyways.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

73-04
05

73-04
02

6. Beam Welding

- TIG weld 78633-05 stop bracket to 100630-03 or 100632-02 tube using ER308L rod, 2 places per tube, down both sides. Use jig to align stop brackets for height and position.
- TIG weld components using ER308L rod:
 - 100630-05 bracket to side of tube using ER308L rod.
 - 100630-04 fitting to back of tube, seat in slot on tube.
 - 100630-06 cap to top of tube.
 - 100630-07 cap to bottom of tube.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

AD
73-04
01

AD
73-04
02

7. Final Inspection

To be completed by a different person than the previous steps.

- Inspect beams for conformity to drawing.
- Tag in-progress parts ready for powder coating.

AD
73-04
02

AD
73-04
02

8. Powder Coating

- Parts are to be powder coated in accordance with commercial practices.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

AD
73-04
02

AD
73-04
02

9. Final Assembly

To be completed after powder coating.

- Adhere P/N placard to back surface of beam.
- Ensure AN5 bolt can be inserted through lugs.
- Green tag complete beam assembly and place into stock.

STRUT FABRICATION – 100635

General

These instructions apply to Struts 100635-01 and 100635-02 and Drag Link 100635-03 for Bell 205/212/412 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

100635, Rev 0 of STRUT FABRICATION
~~100630, Revision 0 – Forward Beam Fabrication, Low~~

Work Order: 2016-137

Complete
(initial or SCA #)

Date Open: 13 OCT 2016

Batch Quantity: 100635-01 Forward Strut: 2
100635-02 Aft Strut: 2
100635-03 Drag Link: 2

100635-01	100635-02	100635-03
AD 73-04 02	AD 73-04 02	AD 73-04 02

1. Fabrication – 3/4"x0.065 tubes

- Cut 3/4"x0.065 material as indicated on drawings.
 - 100635-01: 100635-04 (tube), 15.55" long
 - 100635-02: 100635-05 (tube), 9.8" long
 - 100635-03: 100635-06 (tube), 22.3" long
- Record material PO on attached material list.
- De-burr cut ends.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for turning.

100635-01	100635-02	100635-03
AD 73-04 02	AD 73-04 02	AD 73-04 02

2. Turning

- Load tube in collet in lathe. Ensure tube is not scratched by collet.
- Turn one end flat at 1030 RPM, 0.01 in/rev.
- Deburr ID and OD.
- Flip part, turn end flat and to length specified on drawing at 1030 RPM, 0.01 in/rev.
- Deburr ID and OD.
- Tag completed parts and place on in-progress shelf in welding shop for welding.

AD
73-04
05

3. Welding – 100635-01 Forward Strut

- TIG weld 100635-07 Fitting and 100635-09 Threaded Rod End into 100635-04 Tube using ER308L rod.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts for straightening.

STRUT FABRICATION – 100635

Complete
(initial or SCA #)

100635-01 100635-02 100635-03

4. Welding – 100635-02 Aft Strut

- a. TIG weld 100635-08 Fitting and 100635-09 Threaded Rod End into 100635-05 Tube using ER308L rod.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts for straightening.

AD
73-04
05

AD
73-04
05

5. Welding – 100635-03 Drag Link

- a. TIG weld two 100635-09 Threaded Rod End into tube 100635-06 using ER308L rod.
- b. Record component and welding rod POs / WOs on attached material list.
- c. Tag in-progress parts for straightening.

AD
73-04
02

AD
73-04
02

AD
73-04
02

6. Final Inspection

To be completed by a different person than the previous steps.

- a. Inspect Struts and Drag Link for conformity to drawing.
- b. Tag in-progress parts ready for powder coating.

SET #1
+ #2 JC

AD
73-04
02

AD
73-04
02

AD
73-04
02

7. Powder Coating

- a. Parts are to be powder coated in accordance with commercial practices.
- b. Inspect powder coating on receiving.
- c. Tag in-progress parts ready for final assembly.

SET #1
+ #2 JC

AD
73-04
02

AD
73-04
02

AD
73-04
02

8. Final Assembly

To be completed after powder coating.

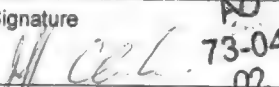
- a. Adhere P/N placard at center of tube.
- b. Ensure AN4/AN5 bolt can be inserted through lugs.
- c. Install AN316-5R Check Nut and AN665-46R Clevis on Threaded Rod Ends. Do not torque check nuts.
- d. Green tag complete beam assembly and place into stock.

SET #1
+ #2 JC

AD
73-04
02

AD
73-04
02

AD
73-04
02

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0286	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice PO 11580	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	RH Forward Beam	100632-01-02	1	WO 2016-137	New	
2.	RH Aft Beam	100633-01-02	1			
3.	Forward Strut	100635-01	1			
4.	Aft Strut	100635-02	1			
5.	Drag Link	100635-03	1			
12. Remarks Certification data: TCCA STC SH07-56						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 23 Nov 2018		14d. Name		14e. Date (dd/mmm/yyyy)
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

BLACKCOMP HELICOPTERS

MOUNTING BEAM FITTING FABRICATION – 100630/100631/100632/100633/100635

General

These instructions apply to Fitting 100630-04, 100631-04, 100635-07 and 100635-08 for mounting Bell 205/212/412 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

100630, Revision 0 – Forward Beam Fabrication, Low

100631, Revision 0 – Aft Beam Fabrication, Low

100635, Revision 0 – Strut Fabrication

Work Order: 2016-137

Complete
(initial or SCA #)

Date Open: 13 OCT 2016

Batch Quantity: 100630-04: 2 100631-04: 2 100635-07: +2 J. 100635-08: +2 J.

1. Stock Preparation

- Cut 1.0 round stock, over 12" long.
- Record material PO on attached material list.
- De-burr cut ends.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining.

AD
73-04
02

2. CNC Machining

- Run CNC programs to machine slots and holes in fittings. Note the same program is used for multiple parts
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in fabrication shop for cutting.

AD
73-04
02

3. Cutting

- On horizontal bandsaw cut the stock machined above as follows:
 - 100630-04 (5/16" hole) – 0.31" from bottom of slot
 - 100631-04 (1/4" hole) – 0.43" from bottom of slot
 - 100630-07 (5/16" hole) – 0.9" from bottom of slot
 - 100630-08 (1/4" hole) – 0.9" from bottom of slot
- Tag in-progress parts and place on in-progress shelf in machine shop for machining.

AD
73-04
02

4. CNC Machining – 100630-04 / 100631-04 only

- Load part in vise using fixture in slot, cut side up.
- Set Z0 as indicated in program. Run program.
- Deburr.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD
73-04
02

5. Turning – 100635-07 / 100635-08 only

- Load part in collet in lathe, cut side out.
- Turn OD to tight fit inside strut tube (3/4 x 0.065 tube) at 1030 RPM, 0.04 in/rev.

AD
73-04
02

MOUNTING BEAM FITTING FABRICATION – 100630/100631/100632/100633/100635

- c. Chamfer end 0.03" at 1030 RPM.
- d. Drill 3/8" x 0.75" deep at 300 RPM.
- e. Deburr.
- f. Tag completed parts and place on in-progress shelf in welding shop for further assembly.

MOUNTING BEAM BRACKET FABRICATION – 100630/100631/100632/100633

General

These instructions apply to mounting beam bracket 100630-05 used for mounting beams for Bell 205/212/412 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

100630, Revision 0 – Forward Beam Fabrication, Low

Work Order: 2016-137

Batch Quantity: 4

Date Open: 13 OCT 2016

Complete
(initial or SCA #)

AD
73-04
02

1. Bracket Fabrication

- Cut 1 x 2 x 0.12 material stock, min 4" long
- Record material PO on attached material list.
- De-burr cut ends.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD
73-04
02

2. CNC Machining - Bracket

- Load stock in CNC vise, tube weld on bottom.
- Run CNC programs to machine slot in 100630-05 bracket. Turn stock and repeat on opposite end.
- De-burr slots and holes.
- Tag in-progress parts and place on in-progress shelf in fabrication shop for completion.

AD
73-04
02

3. Bracket Fabrication

- Set horizontal bandsaw to 26°.
- Load stock tube machined above in bandsaw with slot on far side. Align cut to bottom of ¼" notch. Cut.
- Deburr all edges.
- On vertical bandsaw, cut short edge from bottom of bracket.
- Deburr cut.
- Tag completed parts and place on in-progress shelf in welding shop for further assembly.

Work Order: 2016-137Material Tracking Sheet
Bell 205/212 Aft High Mounting Beams

1 of 1

Date Open: 13 Oct 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>2</u>		100633-01- <u>02</u>	Aft High Beam Assembly	(-XX: -01 = LH, -02 = RH)	
Step 1				<i>Fabrication</i>		
	. 1		100633-03	Tube	304 Stainless, 1x2x0.125 tube	<u>15039</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	. 2		100631-04	Fitting	304 Stainless, 1.0 Round	<u>14103</u>
			100631-05	Cap	304 Stainless, 0.05" Sheet	<u>3021</u>
			100630-05	Bracket	304 Stainless, 1x2x0.125 tube	<u>15039</u>
			100630-07	Cap	304 Stainless, 1x0.125 flat bar	<u>16058</u>
	. 1		69830-07	Block	304 Stainless, 3/16" sqr. bar	<u>2016-77</u>
	. 1		69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	<u>2016-79</u>
Step 4				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>14028</u>
Step 5				<i>Inspection</i>	<i>None</i>	
Step 6				<i>Powder Coating</i>		<u>16073</u>
Step 7				<i>Final Assembly</i>		
	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	<u>See PDS</u>
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	<u>See PDS</u>
	. 1		69830-23	Spring	15mm x 70 mm Spring	<u>See PDS</u>
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	<u>See PDS</u>
	. 1		MS21044C3	Nut		<u>See PDS</u>
	. 1		--	P/N Placard	TZ Tape, 1/2"	commercial

Work Order: 2016-137Material Tracking Sheet
Bell 205/212 Forward High Mounting Beams

1 of 1

Date Opened: 13 OCT 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>2</u>		<u>100632-01-02</u>	Forward High Beam Assembly	(-XX: -01 = LH, -02 = RH)	
Step 1				<i>Fabrication</i>		
	. 1		100632-03	Tube	304 Stainless, 1x2x0.125 tube	<u>15039</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	. 1		100630-04	Fitting	304 Stainless, 1.0 Round	<u>14103</u>
	. 1		100630-05	Bracket	304 Stainless, 1x2x0.125 tube	<u>15039</u>
	. 1		100630-06	Cap	304 Stainless, 0.05" Sheet	<u>3021</u>
	. 1		100630-07	Cap	304 Stainless, 1x0.125 bar	<u>16058</u>
	. 1		100630-08	Guide	304 Stainless, 1x0.125 bar	<u>16058</u>
	. 1		78633-04-XX	Upper Guide	304 Stainless, 1x2x0.125 tube	<u>2016-16</u>
	. 1		78633-05	Stop Bracket	304 Stainless, 3/4" x 0.035" Sqr. Tube	<u>15038</u>
Step 4				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>14028</u>
Step 5				<i>Machining</i>	<i>None</i>	
Step 6				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>14028</u>
Step 7				<i>Inspection</i>	<i>None</i>	
Step 8				<i>Powder Coating</i>		<u>16073</u>
Step 9				<i>Final Assembly</i>		
	. 1		--	P/N Placard	TZ Tape, 1/2",	commercial



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT. Strut No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 100635-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2016-137

Remaining Tasks to be Performed: Inspect, powder
coat.

Signature: David Martz AD
73-04

Date: Nov 9/2018 Lic. No. / SCA 05

In Process



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AMF 73-04

In Process

Remarks



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: APT RH HIGH BEAM No. of pieces: 1

Manufacturer: AERO DESIGN LTD

Part No.: 100653 01-02 Serial/Batch No.: ASN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-137

Remaining Tasks to be Performed: INSPECT, POWDER COAT

Signature: [Signature]

Date: 02 DEC 2016 Lic. No. / SCA AD02

In Process



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AMF 73-04

In Process

Remarks



Aero Design Ltd.

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AMF 73-04

Nomenclature: FWD RH HIGH BEAM No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 100632-01-02 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-137

Remaining Tasks to be Performed: INSPECT, POWDER COAT

Signature: [Signature]

Date: 02 DEC 2016 Lic. No. / SCA AD02

In Process



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AMF 73-04

In Process

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

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AMF 73-04

Nomenclature: Fwd. Strut No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 100635-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2016-137

Remaining Tasks to be Performed: Inspect

Powder coat ✓

Signature: David Mary AD

Date: Nov 9 / 2018 73-04

Lic. No. / SCA 05

In Process



Aero Design Ltd.

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AMF 73-04

Remarks

In Process



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Drag Link No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 100635-03 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2016-137

Remaining Tasks to be Performed: Inspect

powder coat.

Signature: David Marty AD

Date: Nov 9/2018 73-04

Lic. No. / SCA 05

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 100635-12 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2016-137

Remaining Tasks to be Performed: Install

Signature: David M... AD
73-04

Date: Nov 9/2018 Lic. No. / SCA 05

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: 1
Manufacturer: Aero Design Ltd
Part No.: 100635-13 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2016-137
Remaining Tasks to be Performed: Install

Signature: [Signature] AD
Date: Nov 9/2018 73-04
Lic. No. / SCA 05

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

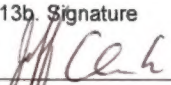
Remarks



WO# 2016-137

WO# _____

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0208
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2016-137
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	RH Forward Beam	100632-01-02	1	N/A	New
	RH Aft Beam	100633-01-02	1		
	Forward Strut	100635-01	1		
	Aft Strut	100635-02	1		
	Drag Link	100635-03	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 08 Nov 2016		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
<p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

ALPINE

Aero Design

Parts Distribution Sheet

Description: Beam Pin

WO# _____

[illegible]

Aero Design

Parts Distribution Sheet

Description: Alpine Basket (Meg)

WO#

[illegible]